

Work Order ID 91504

October-10-12 4:05:09 PM

91504

Page 1

Item ID: D4545-043
Revision ID:
Item Name: Retainer, Inner, LH (Side)

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Start Date: 10/10/2012 Start Qty: 15.00 ***15***

Cust Item ID:

Required Date: 09/11/2012 Req'd Qty: 15.00 ***15***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-11 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4545	C
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100 Pick Kit

0.00

100

Packaging Memo

0.00

Packaging

110

0.00

110

Small Fab Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- DISASSEMBLE AND DEBURR

3- DIMPLE HOLES AS PER DWG

15 12/10/26
15 12/10/26
15 FF 12-10-31

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

DAS

120

15

QC

Memo

0.00

12-10-31

Quality Control

15

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

15 & all at 11:05
completed

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

15

12/11/12

NCR: Yes / No

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145		0.00							
145						15	0		FF 12-11-12
Small Fab	Memo	0.00							
Small Fab	INSTALL NUT PLATES AND ASSEMBLE AS PER DWG								
147		0.00							
147						15			
QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
190		0.00							
190									
Packaging	Identify as per dwg & Stock Location	0.00							
Packaging	Memo	0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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Cust Item ID:

Required Date: 09/11/2012 Req'd Qty: 15.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/11/14 DJ

ME to

12-11-14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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Picklist Print

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Page 1

Work Order ID: 91504

Parent Item: D4545-043

Parent Item Name: Retainer, Inner, LH (Side)

91504

D4545-043

Start Date: 10/10/2012

Required Date: 09/11/2012

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM IPP REV:B
12.02.27 AS PER DWG REV.B DD VERF:EC IPP REV:C 12.05.08
as per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-3		Manufactured	No			100	Each	21.0000	1	15			

D4541-3

Bracket

**

SB 12/10/12

Location

Loc Qty

Loc Code

FG

2

B91412

78276

2

GA

19

87972

1

90615

6

90697

12

D4542-3

Manufactured

No

100

Each

24.0000

1

15

D4542-3

Retainer, Inner

B91452 **

Location

Loc Qty

Loc Code

GA

24

90452

24

MS20426AD3-4

Purchased

No

145

Each

12,752.00

28

420

MS20426AD3-4

RIVET

**

SB 12/10/12
FF 12-11-12

Location

Loc Qty

Loc Code

333

123352

1641

122452

1641

ST316

135

104374

135

ST334

10976

123021

2976

123164

8000

314
106-

NCR: Yes / No

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Required Date: 09/11/2012

Start Qty: 15.00

Required Qty: 15.00

MS21059L3K

Purchased

No

145

Each

1.821.000

14

210

MS21059I 3K

**

Nutplate

FF 12-11-12

Location

Loc Qty

Loc Code

316

123346

30

122452

30

ST316

1791

122814

32

123021

1

123100

758

123265

1000

210

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5F	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

SHOP
RETURN
ENGINEER
UNCONTROL
SUBJECT TO
WITHOUT

WORK
NO. 91504 MJS

12-10-11

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: AFTER FORMING AND PRIOR TO ASSEMBLY, CHEMICAL CONVERSION COAT D4541-X & D4542-X PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC..) VALUE

C	CHG FINISH (ZN AB-1); D4541-5F WAS -5 (C4-1) REMOVE TRANSFER DRILL NOTES	CP	12.04.20
B	ADD FINISH (ZN AB-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4545
TITLE RETAINER, INNER
SCALE NTS

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8 7 6 5 4 3 2 1

91504

D

C

B

A

VIEW A-A
NOT TO SCALE

MS21061L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 40 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
19 PL

0.77
0.51
REF

0.87
0.54 TO BEND TANGENT
(0.60 TO BEND CENTER)

R0.063
BEND

6 8

A#

D4542-1 RETAINER

A1 90°
A2 90°
A3 90°
A4 90°
A5 90°
A6 90°
A7 88°
A8 88°
A9 85°
A10 83°
A11 80°
A12 83°
A13 85°
A14 88°
A15 88°
A16 88°
A17 88°
A18 90°
A19 90°
A20 90°

D4541-1 BRACKET

D4545-041 RETAINER, LH INNER
(LOWER RETAINER)

DESIGN
DRAWN
CHECKED
MFG APPR.
APPROVED
DE APPR.
DATE

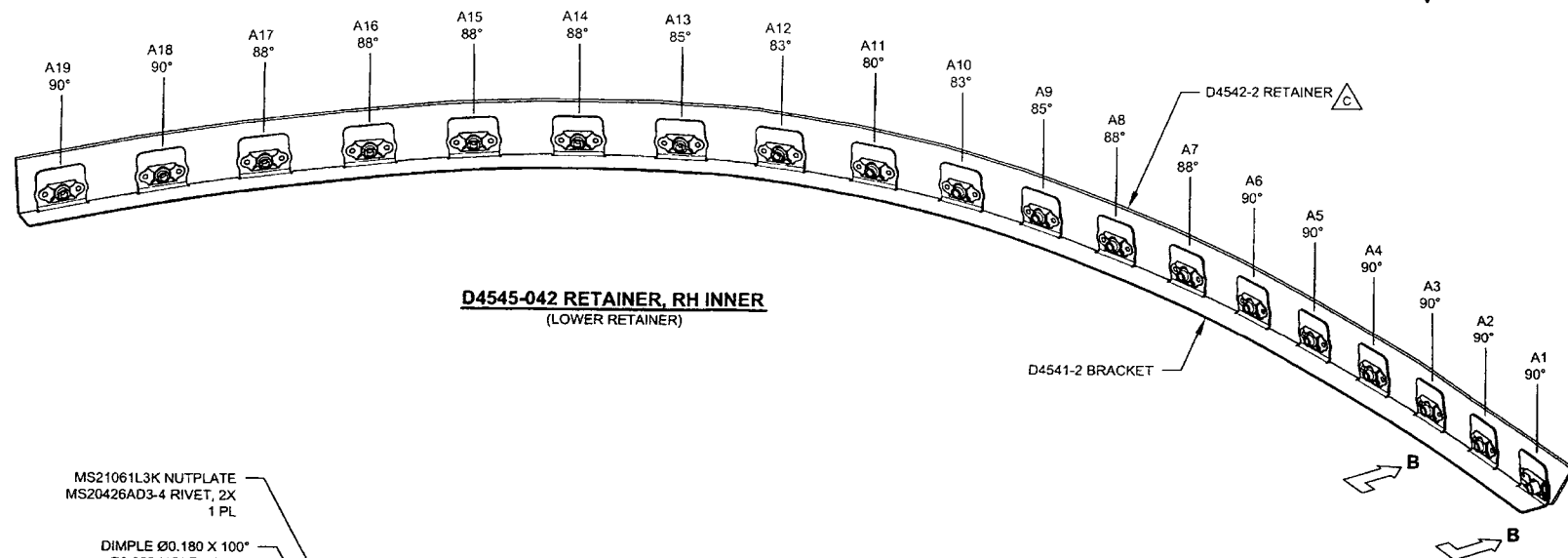
REV. C
D4545
TITLE
RETAINER, INNER
NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

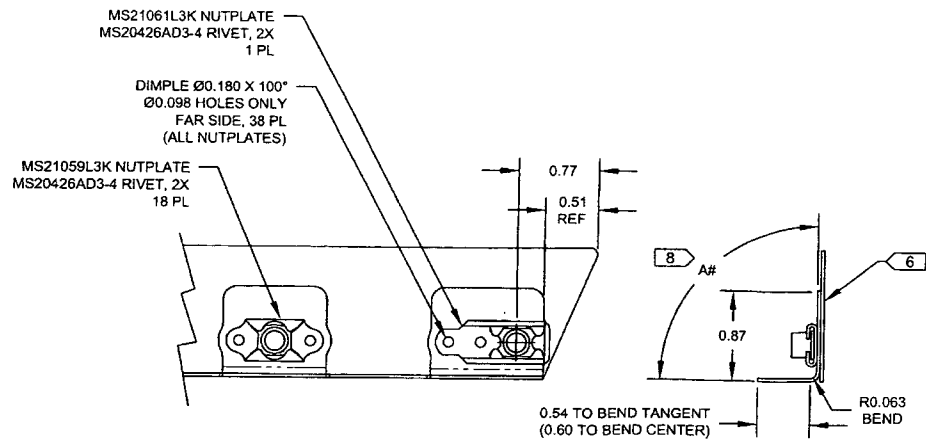
12.04.20

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D4545-042 RETAINER, RH INNER
(LOWER RETAINER)

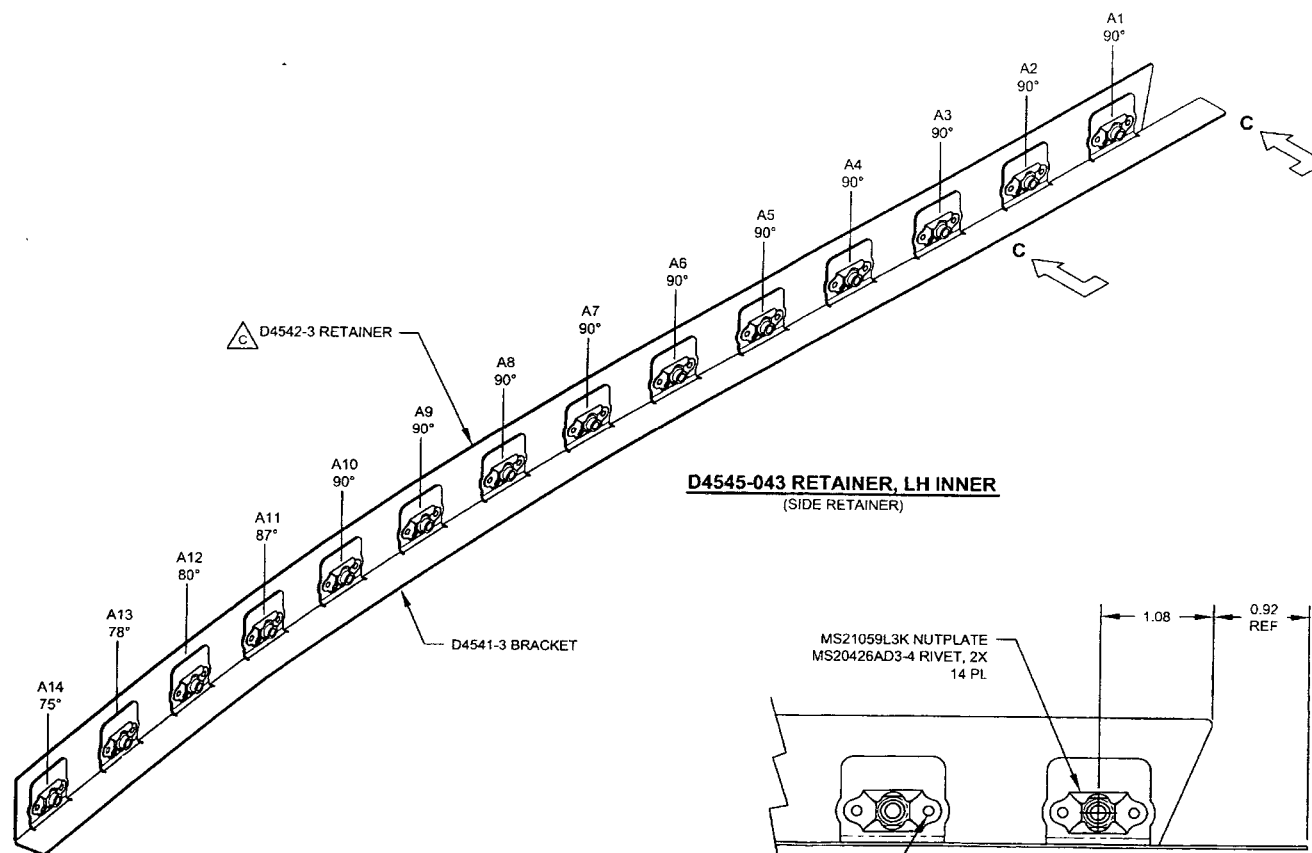


VIEW B-B
NOT TO SCALE

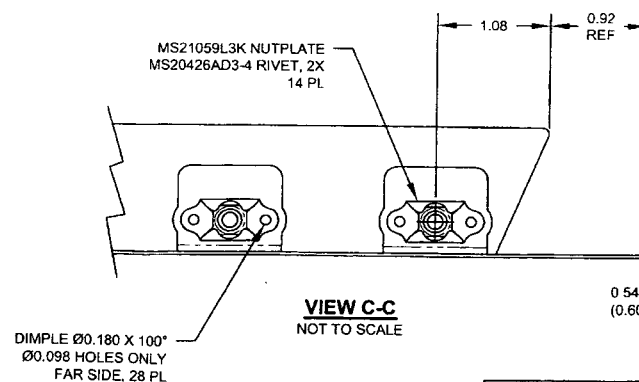
2012-05-07

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4545	SHEET 3 OF 9
APPROVED	AS	TITLE	SCALE
DE APPR	AS	RETAINER, INNER	NTS
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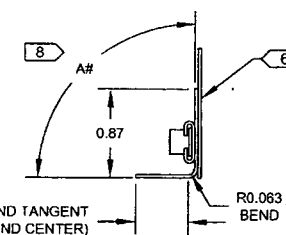
91504



D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

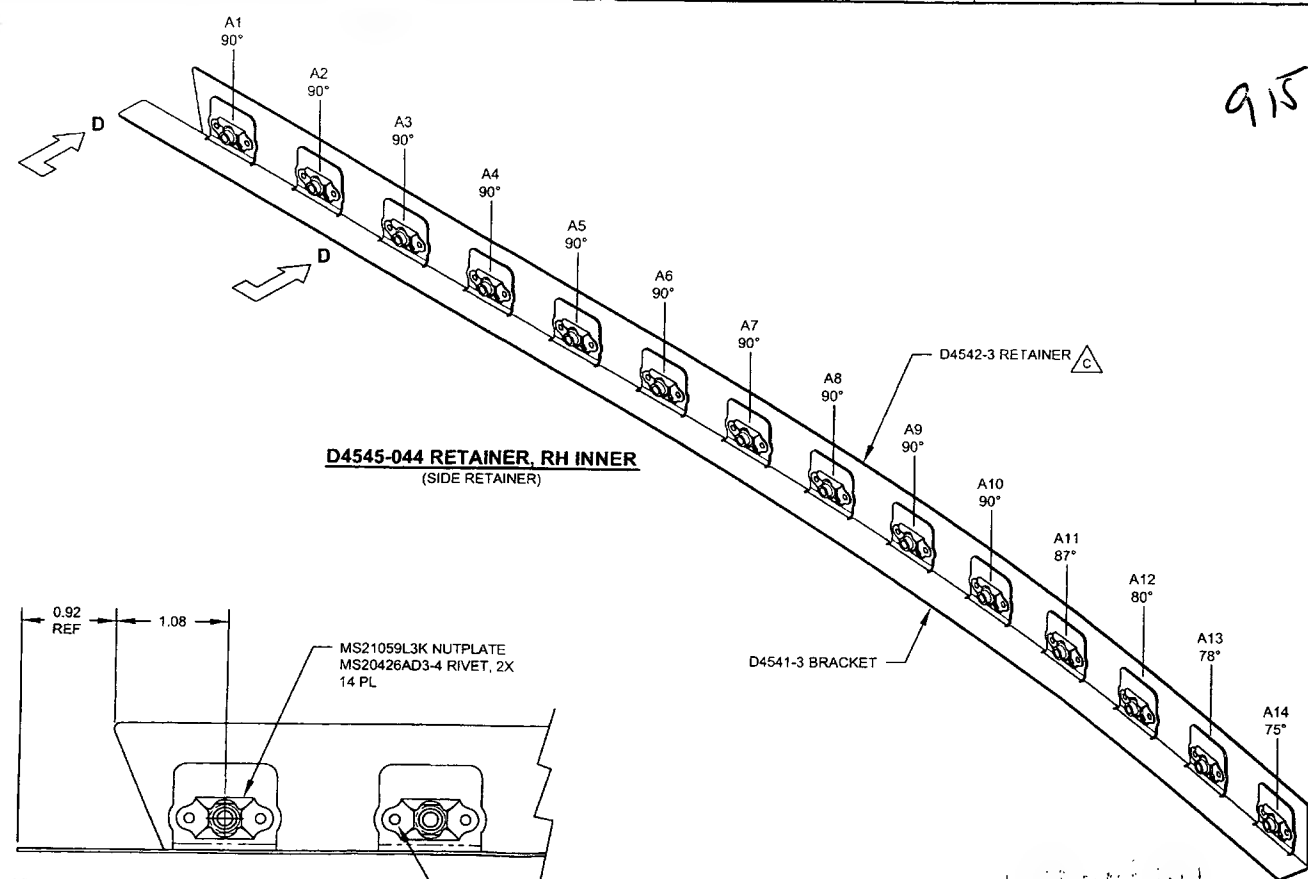


VIEW C-C
NOT TO SCALE

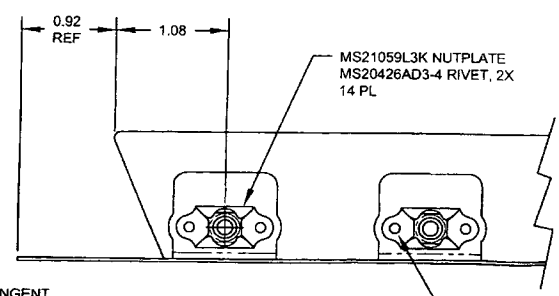
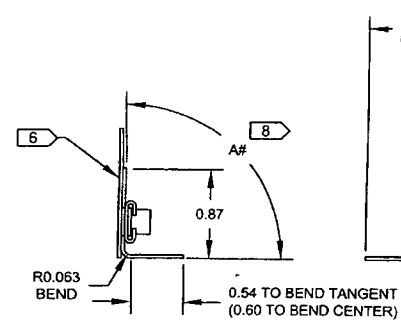


DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 4 OF 9
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D4545-044 RETAINER, RH INNER
(SIDE RETAINER)



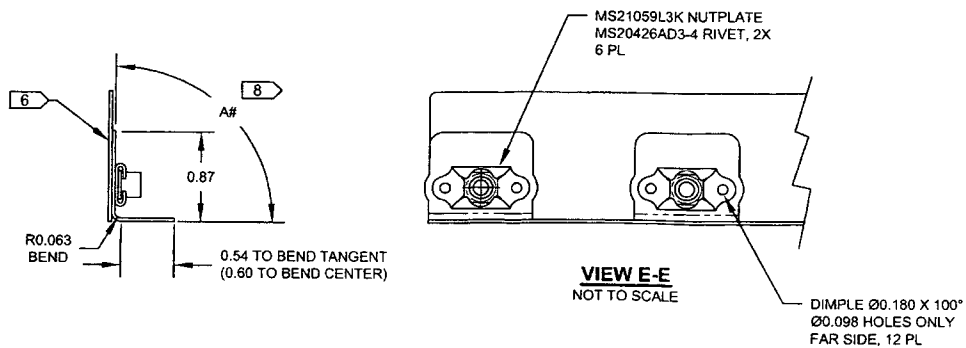
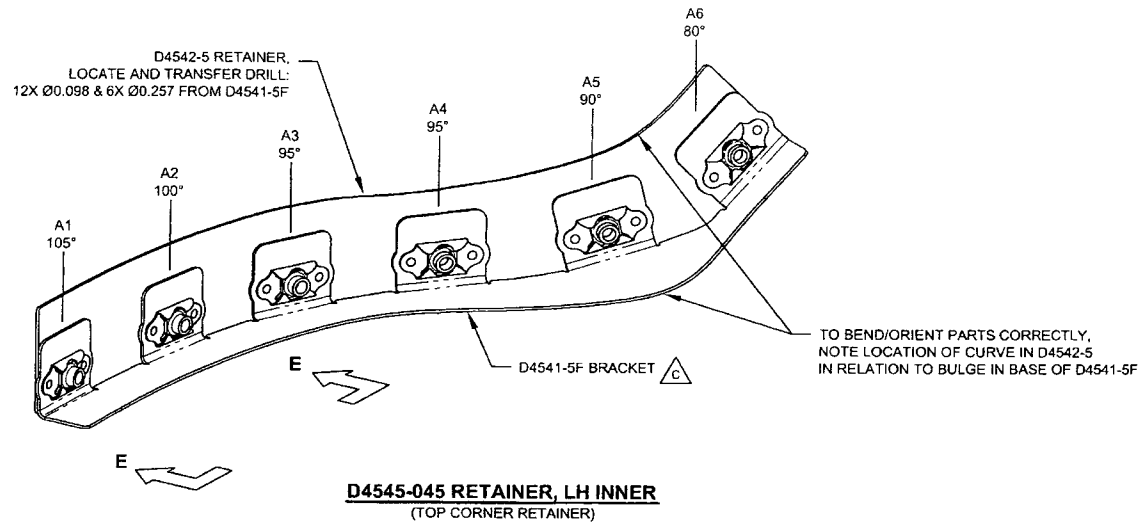
VIEW D-D
NOT TO SCALE

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

2012-05-03

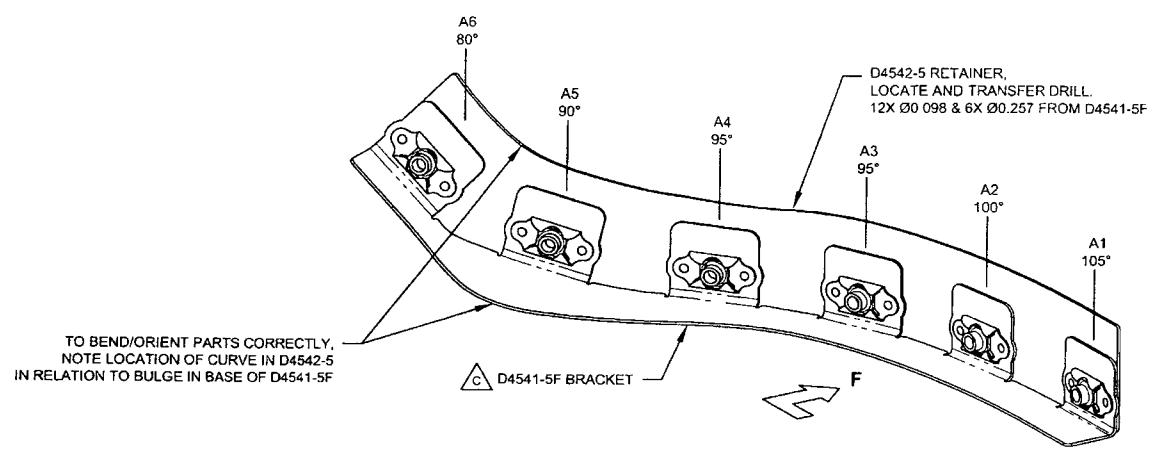
DESIGN	91504	DART AEROSPACE LTD	
DRAWN	91504	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO	REV. C
MFG. APPR.	MA	D4545	SHEET 5 OF 9
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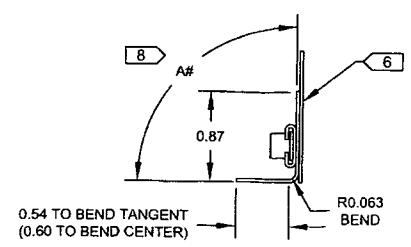
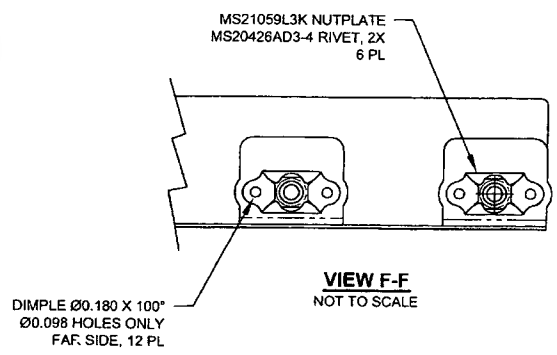


DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO	REV. C
MFG APPR.	AS	D4545	SHEET 6 OF 9
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91504



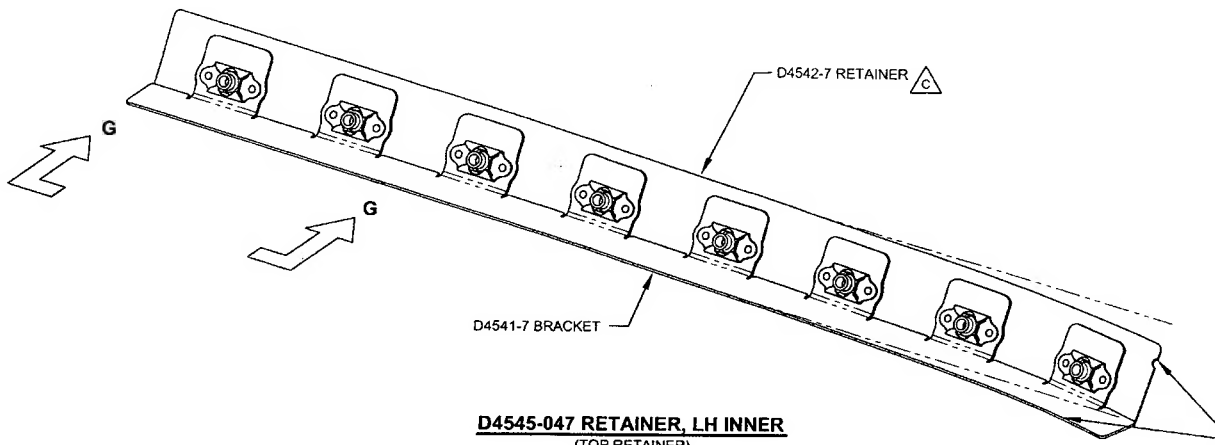
D4545-046 RETAINER, RH INNER
(TOP CORNER RETAINER)



RELEASED
2012-05-07
MP

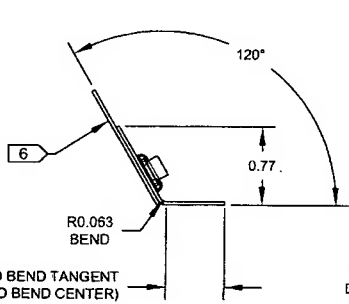
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 7 OF 9
APPROVED		TITLE	SCALE
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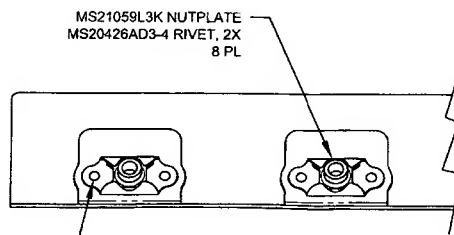


D4545-047 RETAINER, LH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7



0.56 TO BEND TANGENT
(0.60 TO BEND CENTER)



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW G-G
NOT TO SCALE

RELEASED
2012-05-03

DESIGN	91504	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	D4545	SHEET 8 OF 9
APPROVED	AS	TITLE	SCALE
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91504

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

D4542-7 RETAINER

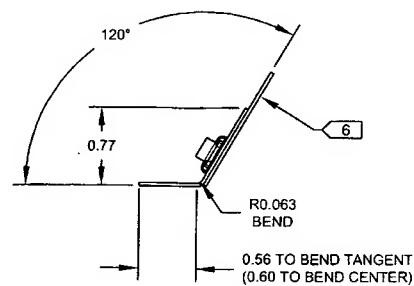
D4541-7 BRACKET

D4545-048 RETAINER, RH INNER
(TOP RETAINER)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



2012-05-03

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4545	SHEET 9 OF 9
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